



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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U/R

D5737-043
Job Sheet 203339

Accounting Job RD19-1069-01



Part No: D5737-043

Job Qty: 1 pcs

Part Name: MID Wearplate Assembly



Part Weight: 0 lbs

Status: New

Job Created: 11/15/19

Job Tracking No:

Due Date: 11/29/19

Created By: Marie Lajeunesse

Type: R+D

Description:

Note: URF 19-1208 DWG D5737 Rev.A IPP Rev. A 19.11.11 New issue DP Verify DD

Ship Via:

POSITIVE RECALL

EFFECTIVE 11/15/19 AUTH. NO

RELEASED 9-89 DATE 19.12-03

PRIORITY: Medium

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	1 pcs	11/29/19	11/29/19	0.00	0.80	Large Fab - 1		EL
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	QC 9	1 pcs	11/29/19	11/29/19	0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	1 pcs	11/29/19	11/29/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		



Container No: S236146



Part: D5737-043

Job No: 203339

Serial No/Batch: S236146

Revision: U/R Rev A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/29/19

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					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
150 Spray Paint - 2 - B4B	1 pcs	11/29/19	0.00 0.17		Spray Paint - 1 - B4B	
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
160 QC 5	1 pcs	11/29/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
170 Packaging 3-1 - Stock - B4B	1 pcs ✓	11/29/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B ✓	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	

DAS
40
9-89

NOV 29 2019

DAS
41
NOV 30 2019DAS
40
40
DEC 02 2019
NOV 29 2019
9-89

Oscar

DEC 04 2019

DAS
9
9-89

ok to release

WPOOS

				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	1 pcs ✓	11/29/19	0.00 0.00	QC 21 - SA - 21 ✓ DAS	WP005
				QC 21 - SA - 70 21	DEC 04 2019
				QC 21 - SA - 53 3-55	

Part Op **100** - 1- Weld D5737-043 to wearplate as per dwg D5737 304 S.S. Welding Rod BATCH #: M136585 2-
 Descriptions: Transfer drill holes in bar 3- Use DT to check fit after welding 4- ENSURE WELDED CLAMP FITS AROUND A
 3.62" DIAMETER WITH 0.375-0.500 THREAD EXPOSED WHEN SNUG.
110 - QC9- Inspect visual per QSI004- Fusion Welds
120 - QC5- Inspect part completeness to step on W/O
150 - BATCH: 5227557 COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040
 THICK, PER DART QSI 005 4.9.
160 - QC5- Inspect part completeness to step on W/O
170 - Identify as per dwg & Stock Location:
180 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D5617-1	Clamp	4 pcs (4 ea)	100-Large Fab - Welded Assy-1	<u>5225562</u>
D5678-1	Hex Nut	4 pcs (4 ea)	100-Large Fab - Welded Assy-1	<u>5252853</u>
D5737-3	MID Weaplate	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	<u>5233486</u>
D5738-043	MID Wearbar Assembly	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	<u>5234988</u>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	D5617-1	4	16	0
	D5678-1	4	37	0
	D5737-3	1	0	0
	D5738-043	2	0	0

Part Specifications	
Specifications could not be found.	

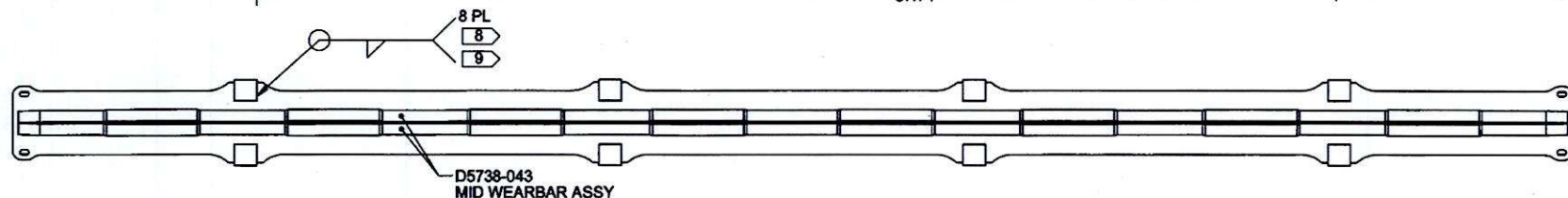
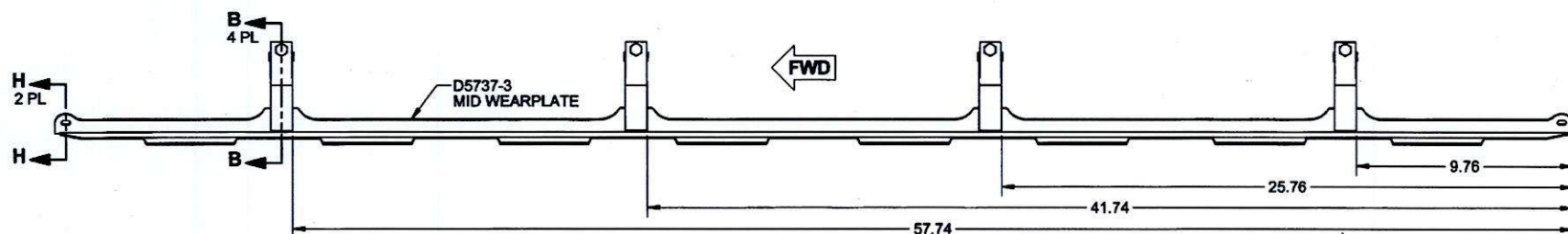
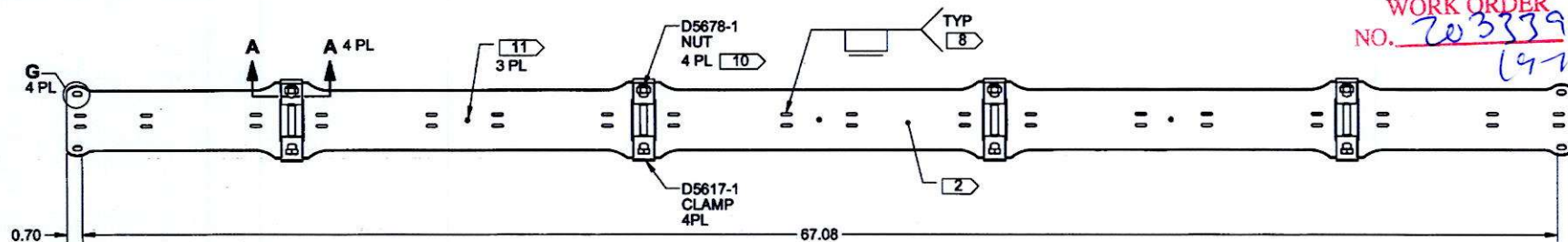
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QTY -043	P/N	DESCRIPTION
X	D5737-043	MID WEARPLATE ASSY
1	D5737-3	MID WEARPLATE
2	D5738-043	MID WEARBAR ASSY
4	D5617-1	CLAMP
4	D5678-1	NUT

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SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 203339M5
191175



D5737-043 MID WEARPLATE ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING PER DART QSI 005 4.9
MASK D5617-1 CLAMPS PRIOR TO FINISH
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5737-043" AND S/N PER DART QSI 044 6.1
- 7) WEIGHT: 12.19 lbs
- 8) WELD PER DART QSI 004
- 9) ENSURE WELDED CLAMP FITS AROUND A 3.62 DIAMETER WITH 0.375-0.500 THREADS EXPOSED WHEN SNUG
- 10) INSTALL HAND TIGHT ONLY
- 11) TRANSFER DRILL $\phi 0.188$ DRAIN HOLES FROM WEARPLATE THRU WEARBAR, OPEN HOLES TO $\phi 0.188$ AFTER FINISH IF REQUIRED

UNDER REVIEW

URF 19-1208 19.11.07 (VM)

APPROVED

DESIGN	ZF	DART AEROSPACE USA, INC. HILLSBORO, OR	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. A
MFG. APPR.	DD	D5737	SHEET 3 OF 9
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	TRAINING WEARPLATES	NTS
DATE	19.08.22	COPYRIGHT © 2019 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

